



Dart Hawkesbury
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D4634-145
Job Sheet 167078-F



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	2017-12-13
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	2017-12-18
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	2017-12-20
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	2017-12-25
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138649 Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18-01-29 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 138649

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5 <u>SC22307</u>	1 <u>5022930</u>	3	0	0
	D4636-5 <u>SC22305</u>	1	43	0	0
	D4647-1 <u>SC22305</u>	1	4	0	0
	D4664-5 <u>SC22303</u>	6	39	0	0
	D4712-1 <u>SC22302</u>	1	4	0	0
	D4732-17 <u>SC22301</u>	1	0	0	0
	D4732-23 <u>SC22299</u>	1	1	0	0
	D4732-27 <u>SC22297</u>	1	1	0	0
	D5021-5 <u>SC22298</u>	1	1	0	0
	MPNY-750S-9-C <u>SC22308</u>	9	570	0	0
	MS20426AD3-4 <u>SC22295</u>	4	5,055	0	0
	MS20426AD4-6 <u>SC22294</u>	2	2,797	0	0
	MS21059L08 <u>SC22291</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	Lot/TV Effective : _____	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	MRB (QSI042) Approval _____
Description Work C				Completed By _____
 S022950 Aft, Center Ceiling Replacement Panel Assembly PART NO: D4634-145 Revision: Operation: Start up Operation Change No:				Lead hand / Supervisor Approval Verification _____
				QC / QA Coordinator Approval _____

Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					